

Date: Wednesday, 3/8/2006 10:38:02 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHROUD ASSEMBLY
Job Number	: 26112 -2		
Estimate Number	: 12198		
P.O. Number	: N/A	Part Number	: D346719
This Issue	: 3/8/2006 S.O. No. : N/A	Drawing Number	: D3467 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 3/31/2006
Checked & Approved By	: [Signature] 06.03.08	Qty:	20 Um: Each
Comment	: est rev. A 06.02.06 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	OUTSIDE SERVICE	OUTSIDE SERVICES
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Comment: Sub-Contracting Issue P/O: 00000768 06/03/09
 Email or Ship DXF file to vendor
 Laser Cut per Dwg D3467 flat pattern D3467-19F
 Material release note required

2.0	D346719F	DOUBLER FLAT PATTERN
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 DOUBLER FLAT PATTERN

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

06-03-22 (20)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

06-03-22 (14) PTO

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Form as per dwg D3467 using DT8852

06-03-25 (17)
 (14) PTO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		One taken for sample	JB	06/03/27	1	JB 06/03/27	JB 06/03/27

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/04/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/04/25	5	3 S rep	JB 06/04/25	destroy	JB 06/04/25	JB 06/04/24	JB 06/04/25	JB 06/04/25

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:38:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD ASSEMBLY

Job Number: 26112

Part Number: D346719

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/04/25 (14)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SB 06/04/25 (14)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/04/25 (14)

Job Completion



in 06-04-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

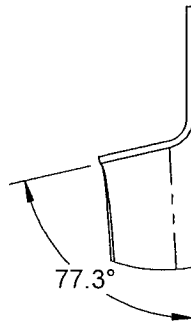
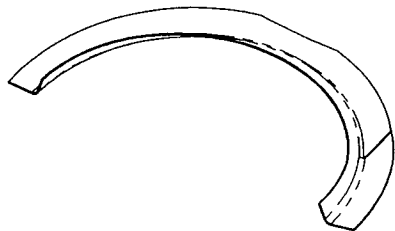
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

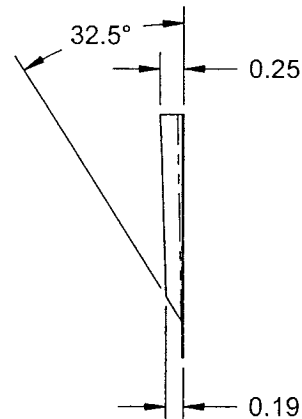
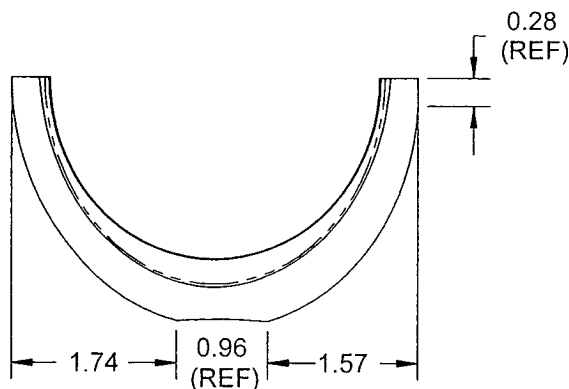
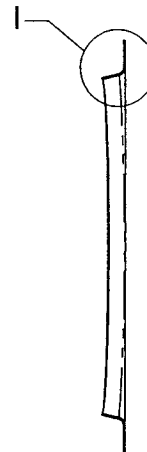
NOTE: Date & initial all entries

PRELIMINARY ISSUE

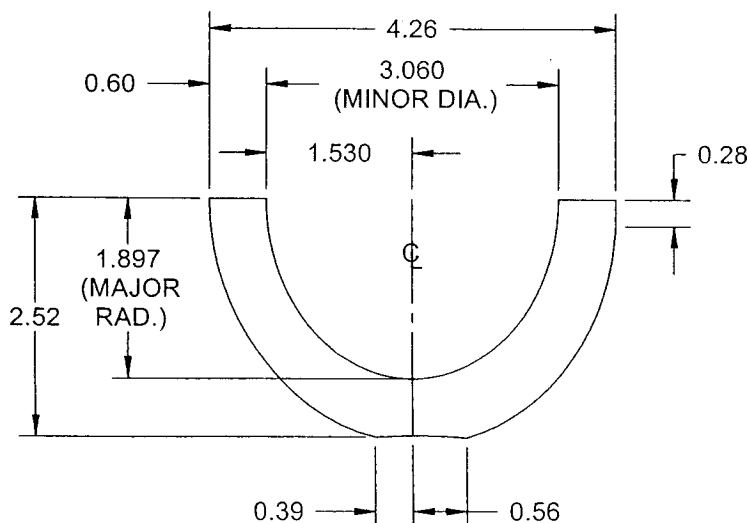
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3467	REV. A SHEET 15 OF 15
DATE 05.12.07	TITLE SHROUD ASSEMBLY		SCALE 1:2



DETAIL I
SCALE 1:2



D3467-19 DOUBLER, LH SHOWN
D3467-20 DOUBLER, RH OPPOSITE



D3467-19F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

3/17/06
604-946-4153
ATTN: JETE

AK Steel		AK Steel Corporation		Page 1	
Metallurgical Test Report		Concoction Works		Lead No. 740672	
Cincinnati, OH 45812				SHEET NO. 740672	
INTEGRIS METALS P.O. BOX 340 MINNEAPOLIS, MN 55440 TEL: 612-554-1000 FAX: 612-554-1001		INTEGRIS METALS 305 'B' STREET ALBURN, WA 98001 TEL: 360-435-1497 FAX: 360-435-1498		MILL ORDER NO. 77206-0191 PROCESSOR ORDER NO. 427135-01 BUYER'S ORDER NO. 427135-01 PART NO. 740672 EXPLANATION - PRODUCT - METRIC UNITS DIMENSION 48.000 X COIL	
SKID ID	PIECE	WEIGHT	PARENT COIL ID	NET WEIGHT	
SK071313	1	75051	650019-02	2445 LBS. 4012 KG.	
SK071314	1	75051	650019-02	2470 LBS. 4013 KG.	
SK071315	1	75051	650019-02	2521 LBS. 4048 KG.	
SK071316	1	75051	650019-02	2441 LBS. 3991 KG.	
TOTAL SKIDS	4			TOTAL NET WEIGHT	
				3846 LBS. 6505 KG.	
CHEMICAL ANALYSIS					
L-Label Analysis of Heat P-Product Analyzed Parent Coil					
ID	C	MN	P	S	SI
L-72051	.049	1.39	.077	.501	.35
				13.18	8.05
				.35	.04
				.30	.12
SHIPPING DATE: 03/14/2005 REMARKS: NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS, RADIUM, ALPHA SOURCE, AND LOW MELTING ALLOYS OR ELEMENTS CAPABLE OF FORMING LOW MELTING ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL. PRODUCT DESCRIPTION CR STEEL TYPE 304 STAINLESS STEEL FINISH SLIT EDGE * AND SHELL * ALL TEST RESULTS HAVE BEEN MET UNLESS NOTED TO OR NOTED OTHERWISE * 2 STR A 240 -04 EX PARA 3.1.1.3 COIL WILL BE IDENTIFIED BY MARK * 9 * RATE * 400 -01 EX PARA 19.1.1.1 ELONG WILL BE IDENTIFIED BY MARK * 8 * EX PARA 26.1.1.3 COIL WILL BE TAGED ON OUTSIDE ONLY * ASSE * 866 -03 * IN-001 Rev 0, * IN-011 0 * BUYER PART# 76251497 * ASSE SA-240 SECTION II PART B (2001 ED, 2002 REVISION) EX PARA 3.1.1.3 ELONG WILL BE IDENTIFIED BY MARK * 8 * EX-10204 3.1.1.3					
PARENT COIL ID	FOR DR	COND	SEALONG	TENSILE STRENGTH (MIN)	YS. AS ORDERED (MIN)
72051	(870)	(L, T, D)	2 INCH MEASURED	(MIN)	(MIN)
				77.1	77.2
				77.1	77.2

*** CONTINUED ON NEXT PAGE ***

Fax Server

T-726 P.008/015 F-527

002/004

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 1
Heat/Lot : 86K8
TIN : B42748

Sold To: INTEGRIS METALS, LTD.
7910 49TH STREET SE
CALGARY, AB T2C2Y3

Ship To: ***CUSTOMER PICKUP***
4375 14TH STREET NORTHEAST
CALGARY
ABT3E7A9

Vendor Information

Cust PO #: 406824

Cust PO DT: 11/03/05

Specifications

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a 480/04a, 666/03, ASMESA240/04-A05, 480/04-A05, SA666/04
Q08766D-A X 1/8 PRM, AMS5513H X MRK&FIN, MILS059D, AMD3, X CRWN MEAS
CORROSION: ASTM A262/02aB, 180Bend-OK
Buyer Part: 4288441
304 2B .1305 IN 48 IN 96 IN
Country of Origin: UNITED STATES

Mechanical Tests

		UOM	L	O		UOM	L	O
Yield Strength - 0.2% Offset	40	KSI	F	TRANSV				
Tensile Strength (UTS)	93.3	KSI	F	TRANSV				
Rockwell B	85		F	TRANSV				
Pct Uniform Elong 2 In/50mm	57.01	PCT	F	TRANSV				
Rockwell A	85		T	TRANSV				

Chemical Composition

C Carbon-Pct	.059	CR Chromium-Pct	18.360
CU Copper-Pct	.342	MN Manganese-Pct	1.643
MO Molybdenum-Pct	.285	N Nitrogen-Pct	.037
NI Nickel-Pct	8.150	P Phosphorus-Pct	.029
SI Silicon-Pct	.289		

Comments

03/17/2006 14:18 FAX 6042729137
04/20/2015 08:27 FAX

INTEGRIS METALS

0004/004
0002

The Chemical Analysis and Mechanical Test
data was received via EDI from the above
mentioned vendor.
INTEGRIS METALS, LTD.

5/17/06
510 00-324282-02
038011 01
502870: 12.6.0000

Date: 03/17/06

CONTROL # : 51060214
PART # : 74271441
135 X 48 X 96

Miscellaneous Data

QA by ERIC REAS 02/01/2006

Material from mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 0087638 cond A
This document certifies the material has been tested in
accordance with applicable specifications described herein
and has met those requirements.

Page : 2
Heat/Lot : 86K8
TIN : B42748

From: NORTH AMERICAN STAINLESS CANADA, IN
740 INDUSTRIAL ROAD NORTH

MATERIAL TEST REPORT